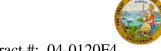
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.22P.A

WELDING WITNESS REPORT

Resident Engineer: Pursell, Gary **Report No:** WWR-000298 Address: 333 Burma Road **Date Inspected:** 07-Jun-2007

City: Oakland, CA 94607

OSM Arrival Time: 800 **Project Name:** SAS Superstructure **OSM Departure Time:** 1730 Prime Contractor: American Bridge/Fluor Enterprises, a JV

Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Contractor: Location:** Shanghai, China

Witness:	Procee	dure Quali	fication Record	Welder Qual	lification	Fracture Critical	
	Weldi	ng	NDT	Mechnical T	esting, describe:		
Index Lot #: B72-037-07				Witness Lot #: B26-011-07			
Bridge No: 34-0006			Component:	Bid: 52,55 Tow	er & Girder		
Welder: Zhu Hai Ping		ID #:	N/A				
Joint Description:		B-U2a		N/A	WPS ID #:	PWPS-B-T-3214	N/A
Base Metal:		A709M-H	PS-485W	N/A	PQR ID#:	HP200778-1	N/A
Thickness:		25 millime	eters	N/A	Process:	SMAW	N/A
Electrode Spec/Class: AWS A5.5/ E9018M MR			N/A	Positions:	Overhead 4G	N/A	
Backing Ma	terial:	A709M-H	PS-485W	N/A	CWI:	Wei Huang	N/A
Average An	ıps:			N/A	AWS Code:	AWS D1.5 2002	N/A
Average Vo	lts:			N/A	Applicable Sec:	Paragraph 5.13	N/A
Travel Spee	d:			N/A	Heat Input:		N/A
Preheat:				N/A	_		

Summary of Items Observed:

1) PQR Test Plate HP200778-1- The Caltrans QA Inspector observed that the presented radiographs for this PQR test plate contain linear indications that are not in compliance with the requirements of AWS D1.5 (2002). It is inconclusive as to whether or not the PQR test plate weld cap with multiple weld passes represents the linear indications within the radiographs. The Caltrans QA Inspector and ZPMC representative Mr. Lu Jian Hua visually observed that the PQR test plate weld cap has been partially ground flush prior to radiographic testing. Mr. Lu Jian Hua stated that the weld cap needed to be completely ground and subsequently radiographically tested again. Radiographic film reviewers for ZPMC and ABF representative Mr. Nate Lindell did not address this issue prior to this review by the Caltrans QA Inspector. Within the Caltrans 6031 for this date the Caltrans QA Inspector captured by digital picture the PQR test plate which contains a partially ground weld cap and also a digital picture of a ZPMC welder grinding the weld cap of the PQR test plate after the Caltrans QA Inspector and Mr. Lu Jian Hua observed that the weld cap was only partially ground.

This 6032 is supported with a Caltrans 6031 for this date.

Summary of Conversations:

As identified within the contents of this report.

WELDING WITNESS REPORT

(Continued Page 2 of 2)

is in general conformance with the contract requirements.

Observed welding, testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Cuellar,Robert	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer